Work Order II June-24-13 1:58:10 F				*10.3	3554*							Page	1
Item ID: D316 Revision ID: Item Name: Baske	t Hoop	¢.		Accept *	*N90	೧೧ 4೧	1100)*	Setup	Start Stop	*N.9	• •	
Start Date: 6/24/ Required Date: 7/05/ Reference:			*25* *25*	⊅ 2√	Cust Ite Custom				Run	Start			
Approvals: Production QC:	cess Plan: MUJ	Date:	13 Tdp-74	o Tooling: SPC (Y/N):	<u> </u>	Date:	. *		Kull •	Stop	*NF	₹1* ₹2*	
Sequence ID/ Work Center ID	Operation Description	/		Set Up/ Run Hours	Tool I	D Tool #	# Plan Code	Accept Qty	t Re Qt			Insp. Stamp	
Draw Nbr	Revision Nbr							-				,,	
D3166	Rev A1										-		
*100 *100 Large Fab Large Fab	Skidtubes 	no 3/4" x 3/4" square t	tubing 60.00" lo	0.00 0.00 ng.			×	<u> </u>		13	<u>-09-</u> 0	25	m,
		٠	•									•	-
*110 *110*	BENDING MAC	HINE - SKIDTUB	ES	0.00				\mathcal{O}		17	09-	NA	Σ Δ
CNC Bend 1	Mer	no		0.00				20		45-	· U7 -	UK	· V+
CNC Delta 100 Bender		n D3166-1 Basket SB, and folio 18.	Hoop as per Dw	rg D3166 using Bendin	g program 350			,					
120 *4.26*	QC6- Inspect dir	nensions to drawing	g	0.00		, <u>*</u>	ć	າກ .		LN.	1/12.	n9.	07
QC	Mer	no		0.00		•	0	K X_X_		<u> </u>	کیا_(<u>و بن</u>	
Quality Control	Insp	ect Basket Hoop di	mensions with t	emplate D3166-1-T1 (E	OT8302)								

DQA:		_ Date:										
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / UPDATE	\٨/	ork Order u	ndate only	AEROSPACE
Q/ 1 G/OSCU.		Dute.			DISPOSITION		<u> </u>	4.041910	•		•	
Work Orde	er:				DISPOSITION			AGAINS				
					Rework]		Skid-tube Crosstub	e		Water Jet	Engineering
Part N	lo				Scrap]		Machining Small Fa	b□	Pro	d. Eng. Coor.	Quality
					Use-as-is		Therr	noforming Finishin	g	Rec/Sto	re/Packaging[Other
NCR N	lo				Suspected Unapproved]		Large Fab Composit	e	j	Supplier	
Root				Desci	L ription of work order update	Τ	Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Cr	nief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data			•									
Equip/Tooling			1									
Handling/Pre												
Material												
Operator												
Offset/Setup												
Process												
Supplier												
Training												
Transport												
Unapproved												
						FA	ULT CA	TEGORY				
Landir	ng Gear			_	General		,		_	_	_	
]	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
]	Centre N	ot Concei	ntric		BOM/Route		Grain		\perp	Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ct _	Temperature/Cure
	Crimp/Ki	nk/Ripple	:/Wave	<u> </u>	Burrs		Inspect	ion Incomplete/Unqualified	\perp	Part Lost/Mi	ssing	Weld .·
	Cuffs			\perp	Contamination		4	tions Incomplete/Unclear	\perp	Part Moved	L	Wrong Stock Pulled
i	Crushing				Countersink	<u> </u>	4 .	gned/off center	\perp	Positioned V		
	Heat Trea			<u> </u>	Cut Too Short	\vdash	Mislabe		L	Power Loss/	Surge	Other
	Inspection	·	Tube	<u> </u>	Drawing	\vdash	Misread					
	Marks/Cl				Drill Holes	\vdash	Off-set					
	Turning S	-		ļ	Finish	\vdash	4	Calibration			·	
	IWave/Tv	vist in Tub	10	- 1	Fit/Function	1	Dut of 9	Seguence				

Work Orde		3554		*103	3554*							Page 2
Item ID: Revision ID:	D3166-1			Accept	*N900	040	100)*	Setup	Start	*N.	S1*
Item Name:	Basket Hoop									Stop	*N.	32*
Start Date: Required Date:	6/24/13 7/05/13	Start Qty: 25.00 Req'd Qty: 25.00	*25* *25*		Cust Item I Customer:	D:						
Approvals:	Process Pia	an:	Date:	Tooling: _ SPC (Y/N):		ate:			Run	Start Stop	171	
Sequence ID/ Work Center II 130 *130* Packaging Packaging	D	Operation Description Identify as per dwg & Sto	ck Location: <u>LUA</u>	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	Qt	y	Reject Number	Insp. Stamp
140 *1 <i>1</i> 0*		QC21- Final Inspection -	Work Order Release	0.00						17	19/9	\mathcal{A}

0.00

Memo

Quality Control

N (309-9

DQA:		_ Date:												
		_			WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE				AEROSPACE		
QA Closed:		Date:			<u>.</u> .	1	7		W	ork Order up	odate only			
Work Orde	er:				DISPOSITION			AGAINST	AGAINST DEPARTMENT/PROCESS					
					Rework	1		Skid-tube Crosstube]	Water Jet	Engineering		
Part N	١٥.				Scrap		Machining Small Fat			Pro	d. Eng. Coor.	Quality		
		·			Use-as-is		Thermoforming Finishing			1	re/Packaging	Other		
NCR N	No				Suspected Unapproved			Large Fab Composite	™		Supplier	1		
Root				Desc	ription of work order update	1	Initial	Action		Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
Design														
Doc/Data														
Equip/Tooling					,									
Handling/Pre														
Material														
Operator	<u>·</u>													
Offset/Setup				-	•	1								
Process														
Supplier														
Training								_						
Transport	_										•			
Unapproved			ł			<u> </u>						<u> </u>		
1		 .				FAI	ULT CA	TEGORY						
Langir	ng Gear				General		le ::			1		٦		
}	Bending	lot Conce	_4_!_	\vdash	Bend BOM/Rauta		1	Program	\vdash	Outside Dim	<u> </u>	Pressure/Forced		
•		iot concei	ntric	\vdash	BOM/Route	<u> </u>	Grain		\vdash	Over/Under	⊢	Set-up		
-	Cracks	مامون ۱۸ راما	/\alaus	\vdash	Broken/Damage/Defect	-	Hardwa		\vdash	Part incorred	—	Temperature/Cure		
}	Cuffs	ink/Ripple	y wave		Burrs	H	1 '	ion Incomplete/Unqualified	\vdash	Part Lost/Mi	ssing	Weld		
	Crushing	<u>-</u> .		` -	Contamination Countersink	H	1	tions Incomplete/Unclear	\vdash	Part Moved	L	Wrong Stock Pulled		
-	Heat Tre			\vdash	Cut Too Short	\vdash		gned/off center	-	Positioned V	· -	Joshan		
ľ	_	ar on Strip in	Tubo		Drawing		Mislabe Misread			Power Loss/	onige	Other		
į	Marks/C	•	lane	\vdash	Drill Holes		Off-set							
}		Sequence		\vdash	Finish	\vdash	1	Calibration						
ļ		wist in Tub		-	Fit/Function	\vdash	4	Sequence						

Picklist Print

June-24-13 1:58:10 PM

Work Order ID:

103554

Parent Item:

D3166-1

Parent Item Name:

Basket Hoop

Start Date: 6/24/13

Required Date: 7/05/13

Page 1

Start Qty: 25.00

Required Qty: 25.00

Comments:

IPP A02.08.23New issueKJ

IPP: B 08.12.05 Updated bending program on step 3 per NCR W/O43165 KJ Verified by: EC IPP Rev: C 09-01-23 as per DEO D3166-A2 DD verified by: EC

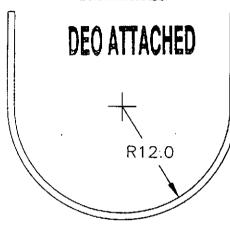
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.065 304 SQ Tube .75x.75x.065	w	Purchased	No			100	f	1,477.2049	5	131.57895			
		· <u>-</u>		Location		Loc Oty	<u>L</u> (c Code					
B7265	38 ×	20"		MAT017		1000.204947							
(p	,,	000		1233	03	0.2049474							
•				1255	13	1000							
				WA006		476.9999263						0.6	
				1250	68 × 90-1	476.999926				0	13-1	09-0	75

DQA:			_ Date:			_								
			_			WORK ORDER NON	-C(ONFO	RMANCE / U					AEROSPACE
QA Closed:			Date:			<u> </u>	-				Vork Order up	odate only		
Work Ord	er.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
***************************************						Rework	1		Skid-tube	Crosstube		Water Jet	П	Engineering
Part	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	П	Quality
						Use-as-is			noforming	Finishing		re/Packaging		Other
NCR	No.					Suspected Unapproved]		Large Fab	Composite		Supplier		
Root					Desc	ription of work order update	l	Initial	Act	tion	Sign &		\neg	
Cause		Date	Step	Qty		or non-conformance	ı	ief Eng		ription	Date	Verificatio	n	QC Inspector
Design		<u> </u>	<u> </u>											
Doc/Data		1											i	
Equip/Tooling]			ļ						ž.			
Handling/Pre			1											
Material														
Operator]											
Offset/Setup														
Process	L		ŀ		l							ļ		
Supplier														
Training				ļ										
Transport														
Unapproved							L							
							FAI	ULT CA1	EGORY					
Landi	ing (Sear			_	General	_	•						
		Bending			Ŀ	Bend		Folio/P	rogram		Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ct		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Ur	nqualified	Part Lost/Mi	ssing		Weld
	<u></u>	Cuffs				Contamination		Instruct	ions Incomplete/L	Jnclear	Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center	[_	Positioned V	Vrong		
		Heat Trea	at			Cut Too Short		Mislabe	led		Power Loss/	Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misread	I					
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of 0	Calibration					
		Wave/Tw	<u>rist in T</u> ub	ре <u>,</u>		Fit/Function		Out of S	equence					
H:/FORMS/Qu	ality	Assurance\a	pproved Q/	A/NCRW) RevH								_	





DESIGN	DRAWN BY	DART AEROSPACE LTI HAWKESBURY, ONTARIO, CANADA	D
CHECKED	APPROVED	DRAWING NO.	REV. A
_ #	9	D3166 SHE	ET 1 OF 1
DATE		TITLE	SCALE
02.07.10		BASKET HOOP	NTS
_A	02.07.10	NEW ISSUE	
AI de Mi	04.04.08	28+/_1 LAC 36.0	



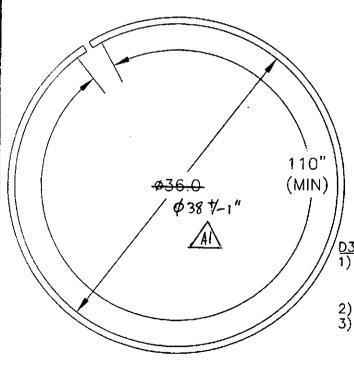
10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

1) MATERIAL: AISI 304/316 SS SQUARE TUBING, 0.75" x 0.75" x 0.063 WALL, 60.00" LONG (REF DART SPEC. M304TS0.750W.063)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3166-3 BASKET HOOP

1) MATERIAL: AISI 304/316 SS SQUARE TUBING, 0.75" x 0.75" x 0.063 WALL, 120.00" LONG (REF DART SPEC. M304TS0.750W.063)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2002 by DART AEROSPACE LTD

IN IS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

			•
•			
·			
	•		
·			
•			

DRAWING NO	TITLE	55				
		, REVA1	DART AEROSPACE LTD	D.E.O NO.	SHEET NO	SCALE
D3166	BASKET HOOP		ENGINEERING ORDER	D3166-A-2	1.08.1	ытѕ
DRAWN AJS	CHECKED	<u>ls</u>	MFG. APPR.	APPROVED ///	DE APPR	
DATE 08.12	.11 DATE අපි.	2.15	DATE 08/12/15	DATE 08/12-/16	DATE 08-12.16	

1) MODIFY MATERIAL NOTE FOR D3166-1 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING, 60.00" LONG

REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING, 0.75" x 0.75" x 0.063 WALL, 60.00" LONG (REF DART SPEC. M304TS0.750W.063)

2) MODIFY MATERIAL NOTE FOR D3166-3 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING, 120.00" LONG

REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING, 0.75" x 0.75" x 0.063 WALL, 120.00" LONG (REF DART SPEC. M304TS0.750W.063)



REASON: SEE PAR 08-005

COPYRIGHT © 2008 BY DART AEROSPACE LTO DOCUMENT IS REVATE AND CONFIDENTIA. AND IS SUPPLED ON THE LEFRESS CONDITION THAT IT IS TO BE USED FOR ANY PURPOSE OF COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WENTER PERMISSION FROM DATA REPOSPACE TO.

